

159448

Tuesday, April 11, 2017 11:05:49 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

?

~

Customer:

Run Start *NR1*

Stop *NR2*

Stop *NR2*

Draw Nbr	Revision Nbr	
D3255	Rev B	

100	0.00	
100		
Large Fab	1.86	2 B 17-4-17
Large Fab		
Large Fab		
	Memo	
	1-Weld as per Dwg D3255 ***purge weld***A/R	SS ROD
	Batch: M134492	2-Grind Welds Flush

110	QC10- Inspect visual per QSI004- ground welds	0.00	
110			<u>2</u>
QC	Memo	0.00	
Quality Control			APR 17 2008 9:36 AM

120	QC5- Inspect part completeness to step on W/O	0.00	
120			
QC	Memo	0.04	<u>2</u>
Quality Control			DAS 38 9.80 APR 17 2021

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :							
Misidentified ☐	☐	Past Due ☐									

Work Order ID 159448

Tuesday, April 11, 2017 11:05:49 AM

159448

Page 2

Item ID: D3255-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Access Panel Assembly
Start Date: 4/17/2017 Start Qty: 2.00 *?
Required Date: 4/21/2017 Req'd Qty: 2.00 *?
Reference: SCHEDULED/S Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>M 136370</i> Memo START TIME: <i>9:30</i> OVEN TEMPERATURE: <i>200</i> FINISH TIME: <i>12:00</i>	0.00 0.37				<i>2</i>	<i>0</i>	<i>17-04-21</i>	<i>333</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02				<i>2X</i>		<i>17/04/25</i>	<i>DAS 36 9-89</i>
150 *150* Small Fab Small Fab	Small Fab Memo 1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255A/R 736 DOW CORNING ADHESIVE Batch: <i>130977</i>	0.00 0.91				<i>2</i>	<i>0</i>	<i>APR 28 2017</i>	<i>DAS 19 9-89</i>

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID 159448

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159448

Page 3

Item ID: D3255-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Access Panel Assembly
Start Date: 4/17/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/21/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.04				2			DAS 38 9-89
Quality Control									APR 28 2017
170	Identify as per dwg & Stock Location: <u>57487</u>	0.00							
170									
Packaging	Memo	0.02				2			DAS 6 9-89
Packaging									APR 28 2017
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.20							
Quality Control									17/5/17

DAS
21
9-89

MAY 01 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Tuesday, April 11, 2017 11:05:48 AM

Page 1

Work Order ID: 159448

159448

Parent Item: D3255-042

D3255-042

Parent Item Name: Access Panel Assembly

Start Date: 4/17/2017

Required Date: 4/21/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3255-2

Manufactured

No

100

Each

4.0000

1

2

D3255-2

Panel

EL 17-4-14

Location

Loc Qty

Loc Code

WA002

4

145876

3

155568

1

D3255-3

Manufactured

No

150

Each

9.0000

1

2

D3255-3

Cap

EL 17-4-17

Location

Loc Qty

Loc Code

WA001

9

145421

1

156179

8

D3255-5

Manufactured

No

100

Each

6.0000

1

2

D3255-5

Gasket

DAS
19
9-89

APR 25 2017

Location

Loc Qty

Loc Code

GA

6

154908

2

157991

4

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

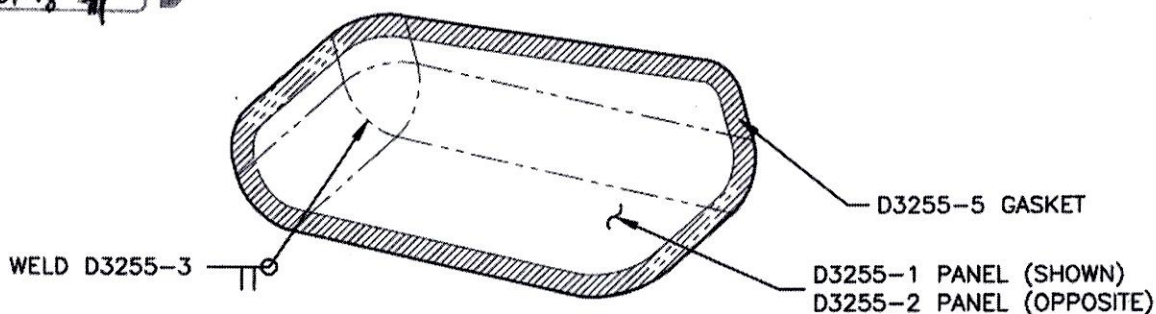
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

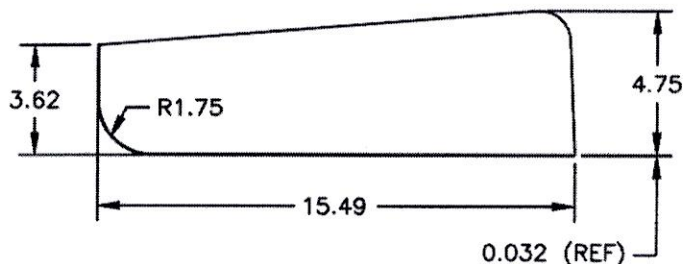
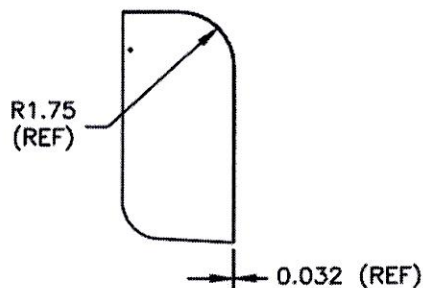
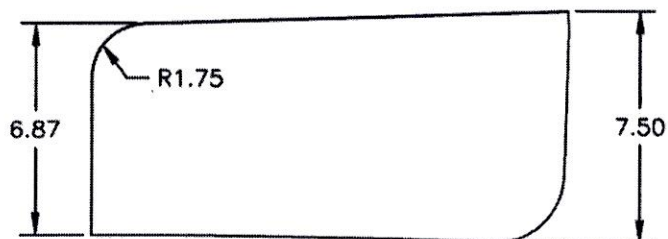


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED up	APPROVED H	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 H



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159448 M5
17-04-11

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
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